

CLAIMS:

1. A method for making reclosable bags comprising:
  - a. connecting a plurality of reclosable fasteners each with two interlocking profile strips to a rectangular sheet of film having two parallel side edges and a top and a bottom edge, each profile strip of each reclosable fastener means being maintained in the interlocked position and being independently connected to the same side of said film, said film being maintained in a flat unfolded state,
  - b. supplying a continuous sheet of said film with said reclosable fasteners and overlapping said side edges of said film to form a tube to enclose said reclosable fasteners on the inside of said tube, said tube having a top edge and a bottom edge,
  - c. sealing said overlapped side edges of said film,
  - d. sealing said bottom edge of said tube, and
  - e. sealing said tube said single bag length from said bottom edge to form a top edge of said bag to enclose a single reclosable fastener.
2. The method of claim 1 wherein said reclosable fasteners are perpendicular to the longitudinal forming axis of said film.
3. The method of claim 1 wherein said reclosable fasteners are parallel to the longitudinal forming axis of said film.
4. A reclosable bag made by the method of claim 1.
5. The method of claim 1 wherein said reclosable fasteners are less than half the width of said rectangular sheet of film.
6. The method of claim 1 further comprising the securing of each end of said reclosable fastener strips to said film whereby air and liquids are prevented from entering or leaving through said ends when a bag is formed from said film and after front wall of said bag has been opened by user to gain access to said reclosable fastener.
7. The method of claim 1 further comprising attaching an easy opening means for providing access through the portion of said front wall covering said reclosable fastener of each of said reclosable bags made from said film.
8. A film for making reclosable bags, said film comprising:

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a. a rectangular sheet of film having two parallel side edges and a top and bottom edge,

b. reclosable fastener means connected to said film for providing a reclosable opening in said film, each profile strip of said reclosable fastener means being independently connected to one side of said film at a location corresponding to each bag to be formed from said film, and

c. each of said profile strips of each reclosable fastener being interlocked and being independently connected to the same side of said film while said film is maintained in a flat unfolded state.

9. The article of claim 8 wherein said reclosable fasteners are perpendicular to the longitudinal forming axis of said film.

10. The article of claim 8 wherein said reclosable fasteners are parallel to the longitudinal forming axis of said film.

11. A reclosable bag formed from the article of claim 8.

12. The article of claim 8 wherein the length of said reclosable fastener means is less than one-half the width of said rectangular sheet of film.

13. The article of claim 8 wherein said rectangular sheet of film with said reclosable fastener means attached is wound into a coil.

14. The article of claim 8 wherein said rectangular sheet of film with said reclosable fastener means attached thereto is fan folded into a stack in a zig-zag fashion.

15. The article of claim 8 wherein said rectangular sheet of film with reclosable fasteners attached thereto is wound into a roll on a supporting core material.

16. The article of claim 8 further comprising a continuous arm connected to at least one of said reclosable fastener strips along its full length, each end of said arm and said reclosable fastener strip being secured to said film whereby air and liquids are prevented from entering or leaving through said ends when a bag is formed from said film and after front wall of said bag has been penetrated by user to gain access to said reclosable fastener.

17. The article of claim 8 wherein said rectangular sheet of film with said reclosable fastener means attached thereto is folded prior to being wound into a roll.

18. The article of claim 16 wherein said continuous arm is connected to one edge of the one of said profile strips, that is farthest from the inside of said film, said one edge

being the edge that is closest to the inside surface of said film.

19. An apparatus for making a film for making reclosable bags said apparatus comprising:

- a. means for supplying a continuous film of plastic,
- b. means for positioning a plurality of reclosable fastener means having first and second interlocked fastener strips on the surface of said film, and
- c. means of independently connecting each of said profile strips of each of said reclosable fastener means to said surface of said film.

20. The apparatus of claim 19 further comprising a means for forming said film into a reclosable bag.

21. A film for making reclosable bags in accordance with the subject matter of claim 19.

22. The apparatus of claim 19 further comprising a means for rewinding said film.

23. The apparatus of claim 19 further comprising a means for positioning said fastener means laterally across said film transversely to the longitudinal forming axis of said film.

24. The apparatus of claim 19 further comprising a means for cutting a single fastener from a continuous roll of reclosable fastener profile strip material.

25. The apparatus of claim 19 further comprising a heat seal means for applying heat to the surfaces of said film and said fasteners for connecting said surfaces together.

26. An article for use in packaging products comprising:

- a. a collapsed tubular web of plastic having front and rear walls of material,
- b. said web including a series of spaced, transverse cross-seals securing said front and rear panels of said material together to define a plurality of bags connected together end to end,
- c. said web including a plurality of spaced tearlines between adjacent bags with each bag having at least one said tearline to permit easy separation of each of said bags from said web,
- d. said web including a plurality of spaced, reclosable fastener means secured to said front wall of said tube material with each of said bags having secured to it at

least one reclosable fastener means, and

e. said web with each of said bags having said reclosable fastener means connected thereto being coilable in a roll.

27. The article of claim 26 wherein said reclosable fasteners are perpendicular to the longitudinal forming axis of said web.

28. The article of claim 26 wherein said reclosable fasteners are parallel to the longitudinal forming axis of said web.

29. The article of claim 26 wherein the length of said reclosable fastener means is substantially the same as the width of said web that said fastener means are attached thereto.

30. The article of claim 26 wherein said reclosable fastener means includes a two-edged flange cover connected to one of said reclosable fastener means whereby first edge of said flange cover is secured to said front bag wall and second edge of said flange cover is unattached whereby it provides a means of gripping said reclosable fastener strip for selectively opening.

31. The article of claim 26 wherein said front panel has a rupturable line of weakness in said front wall adjacent said fastener means, and between said fastener means and said flange cover edge that is secured to said front wall.

32. The article of claim 26 wherein an opening in one end of said bag is created by the avulsion of said adjacent bag at said tearline.

33. The article of claim 26 wherein the ends of said flange cover are secured to said front wall of said bag.

34. A method for making a chain of coilable reclosable bags comprising:

a. supplying a continuous film of plastic web material and moving said film forwardly in a bag forming direction,

b. securing a plurality of reclosable fastener means to the outside surface of said web material, that forms the front wall of each bag,

c. drawing said film forwardly bringing the inside surface of said web material that forms said front wall of each bag juxtaposed to the surface of said web material that forms said back wall of each bag and sealing the longitudinal edges together to form a tube of plastic web material with a front wall and back, and

d. cross-sealing said front wall and said back wall to each other in at least one place on each bag thereby creating each bags top end and bottom end and cutting a tearline in said tube between said seals of each bag whereby a chain of interconnected coillable bags is created.

35. The method of claim 34 wherein said reclosable fasteners are perpendicular to the longitudinal forming axis of said web.

36. The method of claim 34 wherein said reclosable fasteners are parallel to the longitudinal forming axis of said web.

37. The method of claim 34 wherein the length of said reclosable fastener means is substantially the same as the width of the web which said fasteners are attached thereto.

38. The method of claim 34 wherein a rupturable perforation line is cut into said front wall adjacent to said reclosable fastener means.

39. The method of claim 34 wherein said reclosable fastener means includes a flange cover connected to one of said reclosable strips whereby first edge of said flange cover is secured to said front wall and second edge of said flange cover is unattached to provide a means of gripping said reclosable fastener strip for selectively opening of said reclosable fastener means.

40. The method of claim 34 wherein one end of each bag is opened by the avulsion of said adjacent bag at said tearline.

41. The method of claim 34 wherein said chain of interconnected reclosable bags is wound into a roll.

42. The method of claim 34 wherein said chain of interconnected reclosable bags are staggered into a container in a zig-zag fashion.

43. The method of claim 34 wherein said web material that forms said front wall of each bag and said web of material that forms said back wall of each bag is formed from a single web that has been folded upon itself.

44. An extruded plastic reclosable fastener means, comprising:  
 a. two complementary profile strips extending along the length of the fastener and which are constructed to be pressed into interlocked relation,  
 b. one profile strip having a cross-section containing at least one protuberance, and the other profile strip having a cross-section containing a complementary

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groove for lockingly receiving said protuberance,

c. one profile strip having an arm extending from the locking side of said profile strip perpendicular to the direction said protuberance locks into said groove, said arm extending along the full length of said profile strip whereby said arm permits said profile strip to be attached to <sup>the inside wall of a bag</sup> [a flexible film] on said locking side of said profile strip without interfering with entry of said protuberance of said profile strip into said groove of said other profile strip, said profile strip including said arm being positioned farther from said flexible film <sup>So bag wall</sup> than said other profile strip.

45. A reclosable bag comprising:

a. a bag formed from a rectangular sheet of film, said bag having a top end, a bottom end, a front wall, and a back wall, said front wall being connected to said back wall by at least three seams, and

b. a reclosable fastener with two complementary interlocking profile strips extending along the length of the fastener and which are constructed to be pressed into interlocked relation, each being less than the width of and independently connected to the same one of said bag walls.

46. The bag of claim 45 wherein said reclosable fasteners are perpendicular to the longitudinal forming axis of said web.

47. The bag of claim 45 wherein said reclosable fasteners are parallel to the longitudinal forming axis of said web.

48. The bag of claim 45 wherein a fourth seam is formed after said bag has been filled with product.

49. The bag of claim 45 wherein at least one of said seams is formed from an integral fold.

*See Prelim. Amend for new claims 50-55.*